206/407

Work Orde	er ID 91288 9:24:30 AM		288	*912	288*							Page 1
Revision ID:	646.9602 Lower Cutter Assembly, Hig	RE V		Accept	*N900	040	100)*	Setup	Start Stop	*N.	S1* S2*
Start Date: Required Date: Reference:	10/04/12 Start Qty: 10/31/12 Req'd Qty	,	*10* *10*		Cust Item I Customer:	D:						
Approvals:	Process Plan: _MLT		Date: 12-10-0			ate:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II	Operation Description	 I		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rejo		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										·	<u> </u>
646.9600	N/C											
110	Pick Kit			0.00								
110 Packaging Packaging	Μ̃	emo		0.00				-				
											•	٨
120				0.00)	,				
120 Small Fab Small Fab		emo ssemble as p	per dwg and apply loctite	0.00 598 on all mating surface	s per note 2.			6				M(13-08
	A	R LOCTIT	TE 598: 12535C		/							•••
¹³⁰ *130*	QC5- Inspect p	art complet	teness to step on W/O	0.00								
QC Quality Control	M	emo		0.00 DAS . 16 9-89	Blos/27			(K				

									DQA:	Date:				
NCR:	Yes / No				WORK ORDER NON-C	CONFOR	MANCE / U	PDATE						
		.,							QA Closed:	Date:				
Work Orde	or:				DISPOSITION	,	AGAINST DEPARTMENT/PROCESS							
WOIK OIGE					Rework	1 ·	Skid-tube Crosstube			Water Jet	Engineering			
Part No.					Scrap	Scrap Machinir			Pro	Quality				
					Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other			
NCR N	No.				Work Order Update]	Large Fab	Composite		Supplier				
Root				Descri	iption of work order update	Initial	A	Action	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief En	g De	scription	Date	Verification	QC Inspector			
Doc/Data								÷						
Equip/Tooling														
Operator														
Material		İ												
Setup							, ,							
Other							İ]				
Process														
Supplier						İ								
Training														
Unapproved														
					F	AULT CAT	EGORY							
Landi	ng Gear				General			,	٦		1			
	Bending	3		İ	Bend	Grain			Ovalized		Pressure/Forced			

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Over/Under tolerance

Part Incorrect
Part Lost/Missing

Part Moved

Positioned Wrong

Power Loss/Surge

Temperature/Cure

Wrong Stock Pulled

Weld

Other

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Burrs

Broken/Damaged

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

\boldsymbol{Work}	Order	ĪĎ	91288
October	05-12 0.	21.30	AM

*****04000*

October-05-12	-,	.200		^91288*								Page 2	!
Item ID: Revision ID:	646.9602			Accept	*N900	040	100)*	Setup	Start	*N	S1*	***************************************
Item Name:	Lower Cutter	Assembly, High								Stop	*N	S2*	
Start Date:	10/04/12	Start Qty: 10.00	*10	*	Cust Item 1	ID:							
Required Date: Reference:	10/31/12	Req'd Qty: 10.00	*10	*	Customer:								
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:			Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description	را المستح	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp	
*1 4 0		Identify as per dwg & Sto	ock Location: 5146	0.00					_	2.1	10		_
Packaging Packaging		Memo		0.00				_ (X	_	_4_(,	hV . 13	3-08-	. I
150		0021 Fig. 14	w					٠,٨	Λ				
*150 *150*		QC21- Final Inspection -	Work Order Release	0.00			_		1/0	_	_1.	101	
QC Quality Control		Memo		0.00		·		77/	(X)	Э— I	13/09	/26_	
•								Ü	NI	30	9.24		

NCR: Y	es / No				WORK ORDER NON-	CONFC	DRMA	ANCE / UP	DATE							
								-		QA Closed:	. Date:					
Work Orde	r:			50. •	DISPOSITION		AGAINST DEPARTMENT/PROCESS									
•	•	,			Rework]	Skid-tube Crosstube				Water Jet	Engineering				
Part N	0.				Scrap]	Ma	chining	Small Fab	Pro	d. Eng. Coor.	Quality				
					Use-as-is] Th	nermof	forming	Finishing	Rec/Sto	re/Packaging	Other				
NCR N	0				Work Order Update	J	La	rge Fab	Composite		Supplier					
Root				Descri	iption of work order update	Initia	al	Ac	tion	Sign &						
Cause	Date	Step	Qty		or Non-conformance	Chief E	Eng	Desc	ription	Date	Verification	. QC Inspector				
Doc/Data																
Equip/Tooling																
Operator				*												
Material		İ														
Setup			·													
Other							ļ									
Process	_						İ									
Supplier							Ì			1		1				
Training	_															
Unapproved			<u> </u>						·							
						AULT CA	ATEGO	RY		·		· · · · · · · · · · · · · · · · · · ·				
Landin	g Gear			٠	General				_	7		7				
	Bending				Bend	Gra			_	Ovalized	<u> </u>	Pressure/Forced				
	Centre No	ot Conce	ntric to	o/s	BOM/Route	\vdash	dware		ļ	Over/Under	}	Temperature/Cure				
_	Cracks				Broken/Damaged	—		Incomplete		Part Incorre		Weld				
-	Crushed/	Crimped.		<u> </u> _	Burrs			ns incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled				
•	Cuffs			<u> </u>	Contamination	\vdash	intena			Part Moved						
_	Heat Treat		L	Countersink		labeled	i		Positioned V							
<u> </u>	Inspectio		Tube	$oxedsymbol{oxed}$	Cut Too Short		read			Power Loss/	Surge	Other				
	Ripples in			<u> </u>	Drill Holes .	Offs					_					
	Torque W	Vaves in E	extrusio	n	Drawing			ibration								
	Turning S	equence			Finish	Out	t of Seq	uence								

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

October-05-12 9:24:29 AM

Work Order ID:

91288

Parent Item:

646.9602

Parent Item Name:

Lower Cutter Assembly, High

Start Date: 10/04/12

l/12 R

Required Date: 10/31/12

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 Cutter Sub Assembly		Manufactured	No	B# 91790	10 89707 8°	110	Each	0.0000	1	10	W 13	.08.22	
646.9812 Lower Deflector, High		Manufactured	No	B#29843	3	110	Each	0.0000	1	10	WA 13.	08.22	
MS21042L08 Nut		Purchased	No			110	Each	1,339.0000	3	30	W/13.	28 39	
MS27039-08-19 Screw NAS1149FN832P Washer		Purchased Purchased	No No	Location 315 1224 ST315 1228 ST317 1221 13 # 10 5 7	314 41	47 47 500 500 792 792 110	Each	0.0000 325.0000	3	30	1	9·22 8·22	
				Location 275 1224	41	Loc Qty 200 200]	Loc Code	1239	.00	A.F.		
				ST275	58	125 125							

										DQA:	Date:	
NCR:	Yes / 1	lo			WORK ORDER NON-	COI	NFOR	AANCE / UP	DATE	QA Closed:	Date:	
					T					. Free Committee Committee		
Work Orde	er:				DISPOSITION		1		AGAINST DE	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descri	iption of work order update	T	Initial	Act	tion	Sign &	-	
Cause	Da	e Step	Qty	I	or Non-conformance	j .	nief Eng		ription	Date	Verification	QC Inspector
Doc/Data				1								
Equip/Tooling								; 				
Operator								1				,
Material												
Setup												
Other												
Process	Ш											
Supplier	Ш			•								
Training												
Unapproved						<u> </u>		<u></u>		<u> </u>	<u> </u>	<u> </u>
						AUI	T CATE	<u> </u>				
Landi	ng Gear			_	General □ .		1			٦	Γ-	7
	Bend	_			Bend	\vdash	Grain		<u> </u>	Ovalized		Pressure/Forced
		e Not Conc	entric to	0/5	BOM/Route	\vdash	Hardwa		ļ	Over/Under	 	Temperature/Cure
	Crack			<u> </u>	Broken/Damaged		4	on Incomplete		Part Incorre	-	Weld
		ed/Crimpe	d.	<u> </u>	Burrs	\vdash	4	ions Incomplete/U	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs			 	Countarial	\vdash	Mainte		 	Part Moved	Mrana	
	Heat		in Tules		Countersink	-	Mislabe		-	Positioned V		Jothan
	-	ction Strip i	in Tube		Cut Too Short Drill Holes	-	Misreac Offset	ı		Trower ross/	onike	Other
		es in Bend e Waves in	Cyteus:-	<u> </u>	⊣	\vdash	1	Calibration				
	ı Irorqu	e waves in	ı cxtrusic	111	Drawing	1	Jour of C	anuration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

•													
			EN	IGIN	EER	ING CHANG	E NOTICL		027	43	SHE	ET 1	JF 1
	A	PICAL	DΨ	/G N	<u>ا ۱</u>	646,9600	REV:N/C	PREPARED BY	S.HUFF	DATE	E: 01/07/10	G EFFECT	T DN DWG MUNINC.
II	NDL	ISTRIES, INC	D\	/G 7	ΓITL	E	(CUTTER	ASSY				
			3	OVED 1	BY, ENC	SR Brand	MFG Armu	1 Town	ac	Multe	EFF	NEXT ORI	ER
	A-AI	ACTION CODES (TC): D C-CREATE VISE D-DELETE	RE	ASDI	N: RE	VISED SCREW	LENGTH.	138	1 2	- 4 <i>A</i> 2 · · · · · · · · · · · · · · · · · ·	7		
										SUE		NT	
3	R	601.3157	3	3	3	SCREW				MS27039-081	8		
			.9603	.9602	.9601								
	ــــــــــــــــــــــــــــــــــــــ	PART NUMBER		QTY		DESCRIPTION					L/SPECIFICA		
טםמ	JUME	ENTS EFFECTED:		MDL		ISTALL INSTRUC	: ⊠ ICA □	FMS 🖾 B🗆	CHANGE C M MAJOR	ATEGORY MINOR	DER REVIEW ☐ YES	REQUIRED ⊠ N□	

